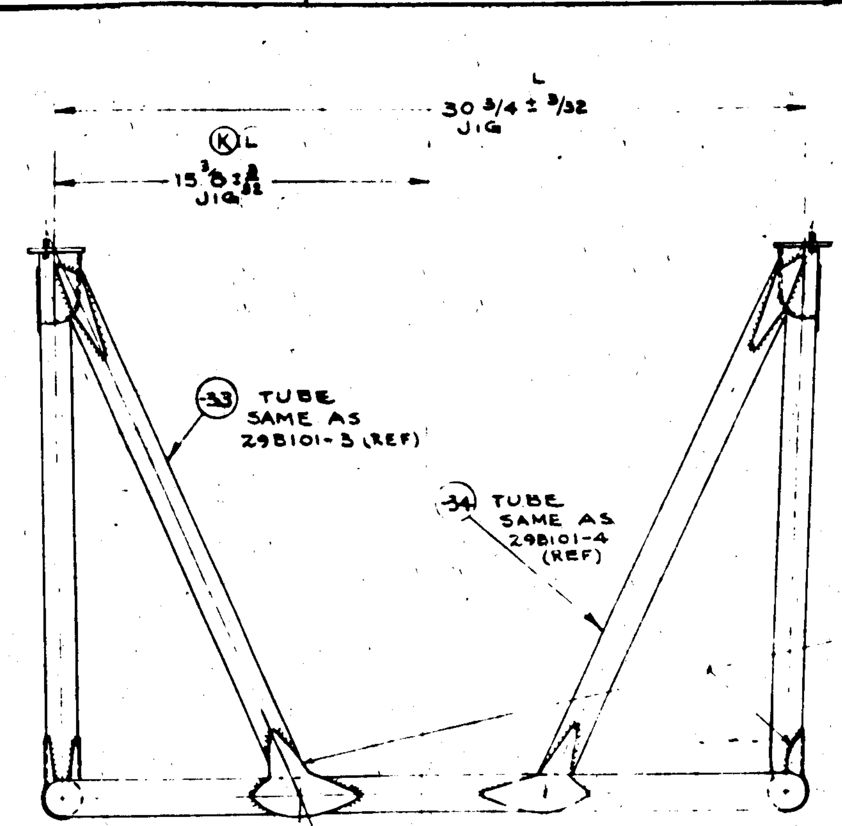
1	2	3	4	5	6

LET	ALTERATION	DATE	BY
A	DIM 7/16 WAS 7/16 REMOVED OTHER 7/16 DIM	4-1-40	J. BAIR
	ADDED 1.890 DIM.	-	
B	ADDED NOTES #6 & #7, REVISED FINISH NOTE IN B/M	9-1-40	
C	REVISED NOTE #6.	4-11-41	
D	REVISED DIM'S. FROM ℄ TO LUGS AND ADDED TOL. NOTE	"	"
E	REMOVED -37 -38: REVISED -36 & -39: ADDED NOTES AT SECT. B-B		
	CHANGED LOCATION OF 2 8-32 TAPPED HOLES		
F	SPLIT GUSSETS: -44, -45 WAS -11; -42, -43 WAS -12; -40, -41 WAS -19 REMOVE NOTE: "CUT OFF ..."		
G	ADDED NOTE		
H	ADDED NOTE		
J	.751 ± .001 WAS .750 ± .0005		
K	17 3/16 WAS 17 3/16 ...		
L	DIM. CHG'D. 30 3/4 ± .010 TO 30 3/4 ± 3/32; 15 3/8 ± .005 TO 15 3/8 ± 3/32; 17 3/16 TO 17 3/32 & 34 3/8 .010 TO 34 3/32		
M	NOTE ADDED TO DET C		
N	ADDED NOTE 8		
O	ADDED NOTE 9		
P	CHANGED SECTION B-B TO SUIT 28B5010 DIM. NOTE CHANGED: TUBE FLATTEN WAS 3/16.	5-14-41	

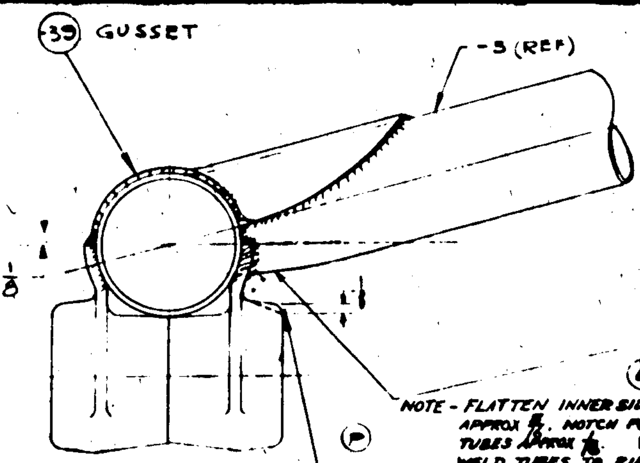
E.O. #18903-A; E.O. #13983-B; E.O. 20996; E.O. 27591; E.O. 27595; E.O. 17340; E.O. 19829; E.O. 25800; E.O. 21141C; E.O. 27595A; E.O. 36675

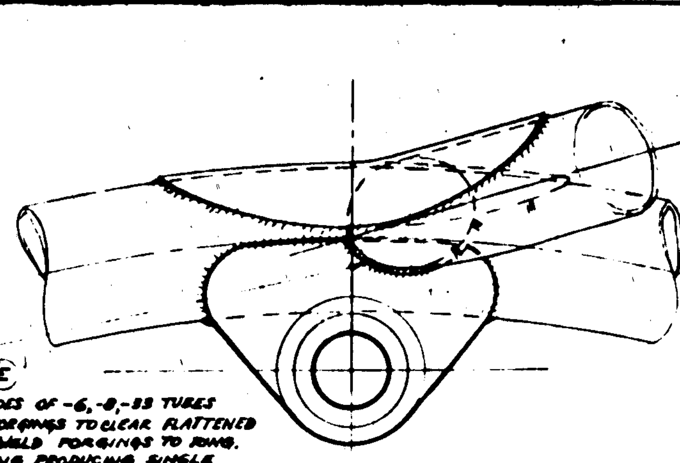
LET	ALTERATION	DATE	BY
R	REVISED NOTE 6 ADDED TO B/M #2 x 3/16 DRIVE SCREWS.	7-16-41	
	REQ./AIRPLANE SET TO DATE.		
S	ADDED NOTE "USE EITHER GAS WELDING OR ELECTRIC WELDING ON MOUNT" (NEG WT CHG)	3-9-42	
T	CHG'D NOTE 7 - (MAGNAFLUXED BY CIRCULAR METHOD ONLY) WAS (IS MAGNAFLUXED-) (NEG WT CHG).	3-11-42	
U	IN SECT. A-A DIM. 1.890 ± .000 WAS 1.890 ± .000 WT. CHG. NEG.	3-19-42	
V	ADDED NOTE #11 NO WT. CHG.	3-19-42	
W	ADDED NOTE "NOTE: ALTERNATE- ---- COND N." NEG. WT. CHG.		
X	ADDED NOTE #13 NO WT. CHG.		
Y	-6. 1 3/8 O.D. x .049 x 29 WAS 25. NO WT. CHG.		
Z	ADDED NOTES #14 & 15. NEG. WT. CHG.		
AA	REPLACED NOTE #14 "GAY ENG'G ---- 28B5010" & NOTE #15 "KELLETT ---- 28B5010" WITH NOTE #14 "28B5276-0 ---- 28B5010" NO WT. CHG.		
AB	IN DETAIL "C" 1/4 MINIMUM WAS 1/4 MINIMUM EDGE DISTANCE. CORRECTED SECT. A-A TO AGREE WITH 28B5010. NO WT. CHG.		



PLAN VIEW

SEE DETAIL C

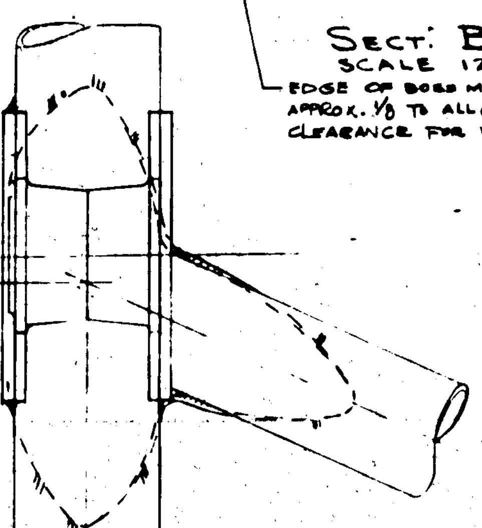




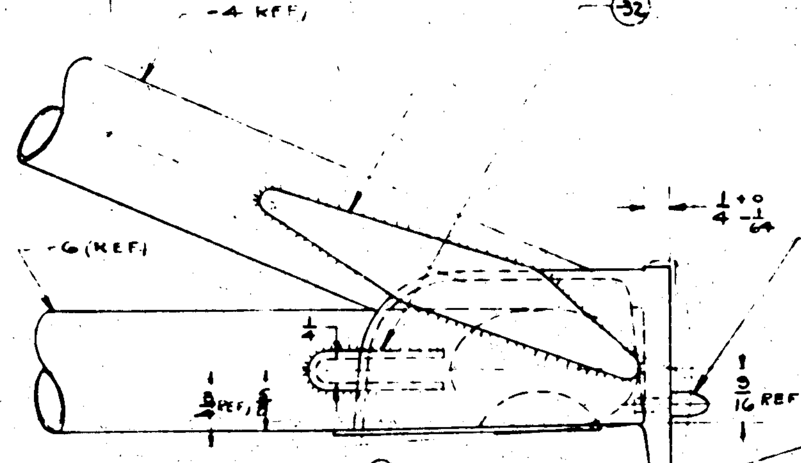
NOTE - FLATTEN INNER SIDES OF -6, -8, -33 TUBES APPROX. NOTCH FORGINGS TO CLEAR FLATTENED TUBES. WELD FORGINGS TO RING. WELD TUBES TO RING PRODUCING SINGLE LINE OF WELDING

SECT. B-B
SCALE 12" = 1'-0"
EDGE OF 2088 MAY BE TRIMMED APPROX. 1/8 TO ALLOW ADDITIONAL CLEARANCE FOR WELDING

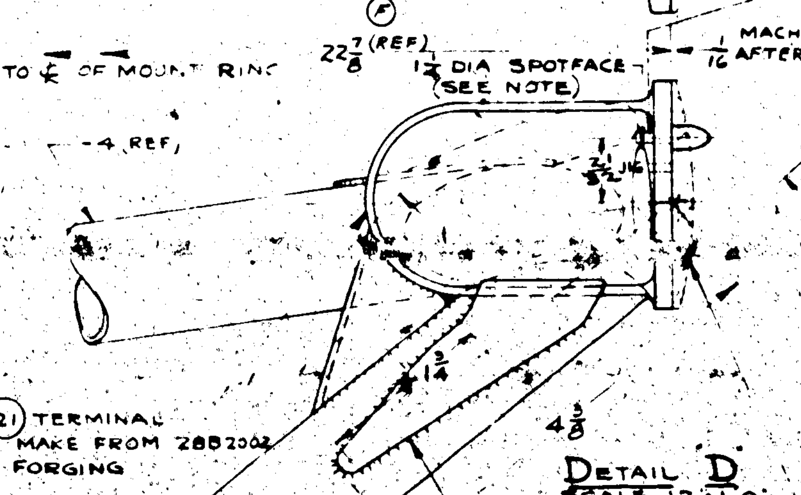
EXTEND GUSSETS FARTHER AROUND TUBES -6, -8, -33 AS SHOWN



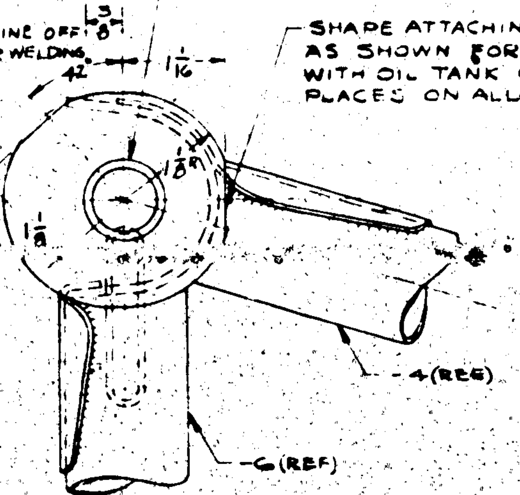
(22) LH UPPER
(23) LH LOWER
(24) RH UPPER
(25) RH LOWER
(32)



28B2032 DOWEL
PEEN END OF DOWEL ON MOUNT
REAM .156 ± .001
CSK 90° x 7/32 DIA
FRONT SIDE ONLY
REAM .8125 ± .0005
AFTER HEAT TREAT
28B2007-2 BUSHING



SHAPE ATTACHING TERMINALS AS SHOWN FOR CLEARANCE WITH OIL TANK CORRESPONDING PLACES ON ALL TERMINALS

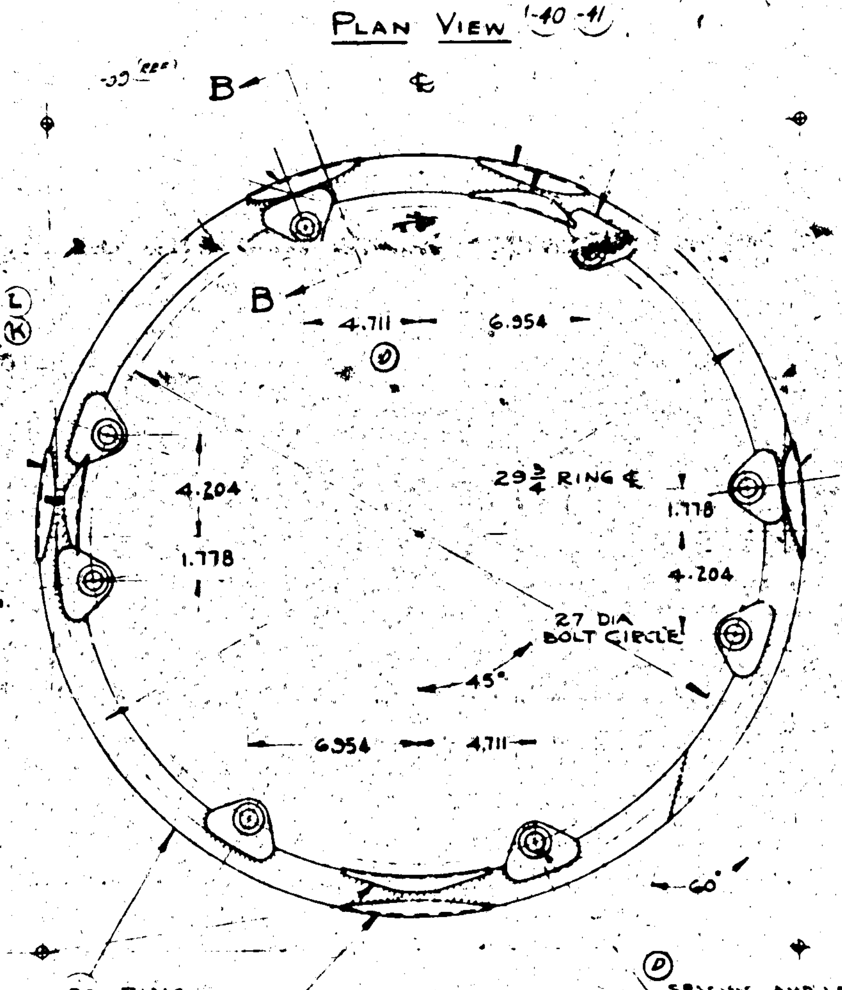


(21) TERMINAL MAKE FROM 28B2002 FORGING

DETAIL "D"
SCALE 12" = 1'-0"

(26) LH UPPER
(27) LH LOWER
(28) RH UPPER
(29) RH LOWER

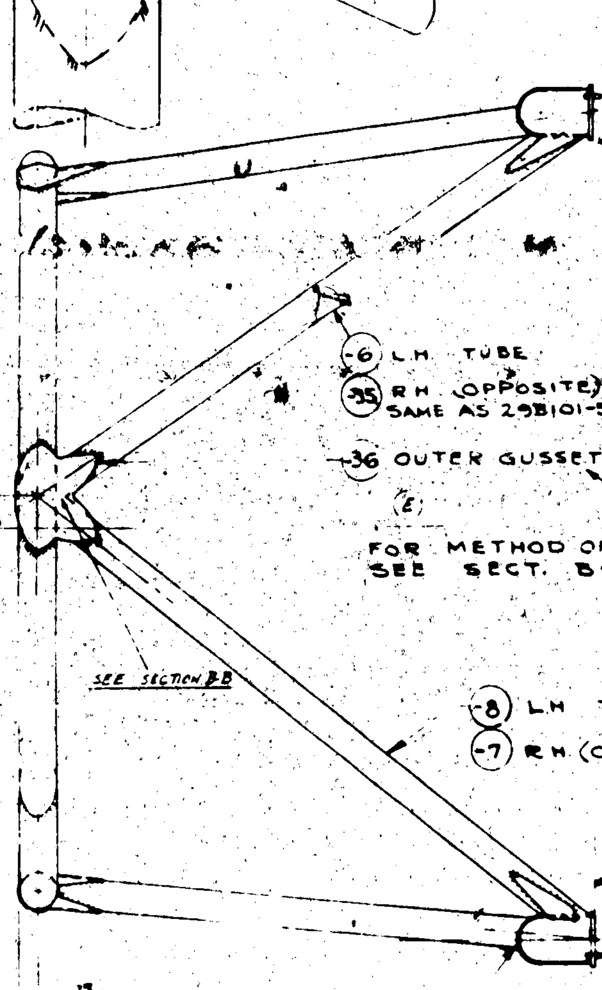
MACHINE OFF SHADED PORTION BEFORE WELDING



(20) RING
VIEW LOOKING AFT
(42) (43) GUSSET

SPACING AND LOCATION OF HOLES SHALL BE HELD TO ±.005.

FRONT FACE OF MOUNTING LUGS MUST BE KEPT IN SAME PLANE WITHIN ±.005



(6) L.H. TUBE
(35) R.H. (OPPOSITE) SAME AS 29B101-5 (REF)
(36) OUTER GUSSET L.H. SIDE ONLY
FOR METHOD OF CONSTRUCTION SEE SECT. B-B.
(8) LH TUBE
(7) RH (OPPOSITE)

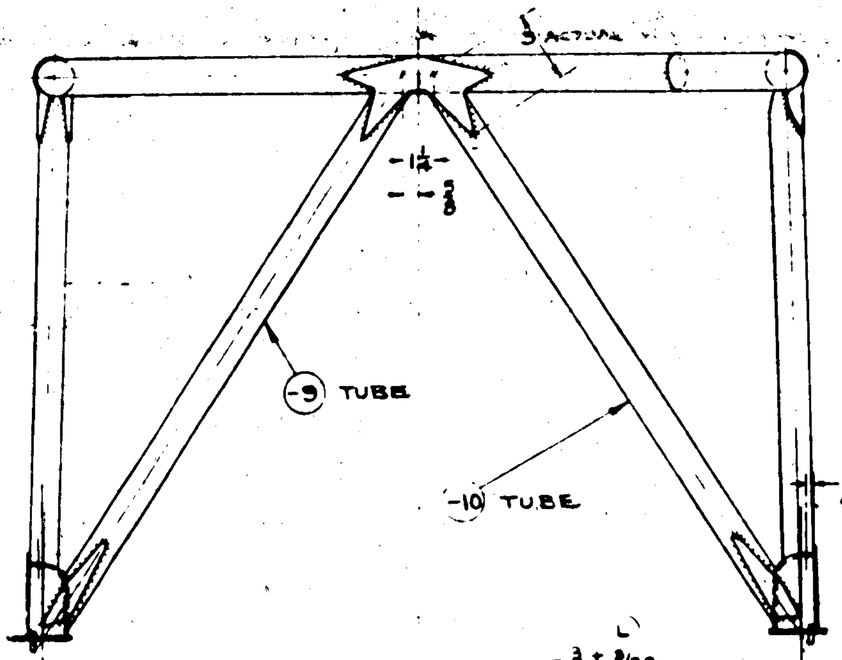
SIDE VIEW

FACE OF FOUR TERMINALS MUST BE KEPT IN THE SAME PLANE WITHIN ±.010. THIS FACING OPERATION TO BE COMPLETED BEFORE 1 1/4 DIA SPOTFACE SEE DET. D.

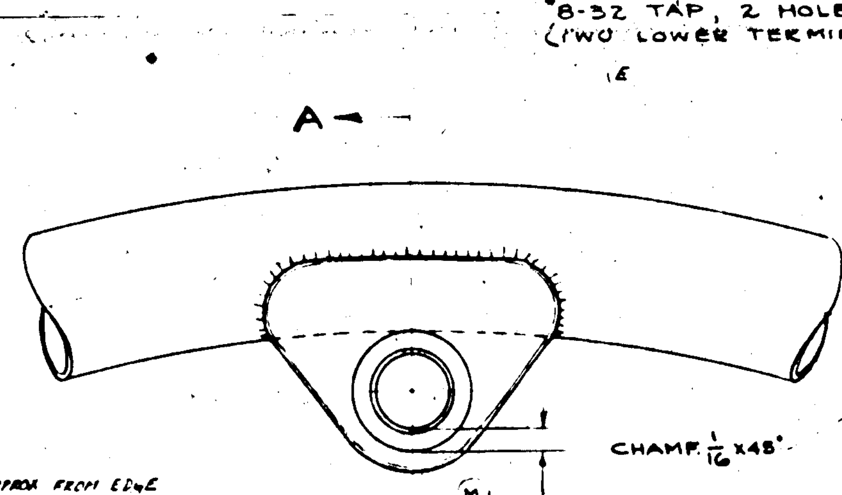
NOTE: THE FRONT FACE OF THE FRONT MOUNTING LUGS & THE REAR FACE OF THE REAR ONES MUST BE HELD PARALLEL WITHIN .018

(H) NOTE: OMIT ALUMINUM SPRAY FROM ALL MACHINED SURFACES.

#8-32 TAP, 2 HOLES PER MOUNT (TWO LOWER TERMINALS ONLY.)

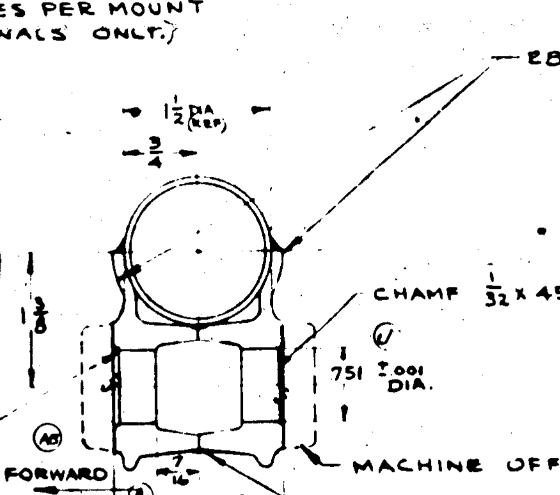


BOTTOM VIEW



DETAIL "C"
SCALE 12" = 1'-0"

28B5010 LUG



SECT. A-A
SCALE 12" = 1'-0"

NOTE - ALTERNATE MATERIALS FOR -6, -7, -8, -9, -10, -33, -34, & -35 CHROME-MOLY WELDED TUBING AN-T-3 TYPE I, COND N. & CHROME-MOLY SEAMLESS TUBING AN-WW-T-850 COND N

H-117

—NOTES—

1. ALL TUBES ARE C.M. STEEL SPEC. 57-180-2 (ARMY), SPEC. 44T18 (NAVY)
2. ALL SHEET STOCK OF MOUNT WELD ASSEMBLY IS C.M. STEEL SPEC. 47S14 (NAVY), SPEC. 57-136-8 (ARMY)
3. ALL TUBES MUST BE COMPLETELY SEALED, WITH #2 x 3/16 U-PK DRIVE SCREWS
4. MOUNT IS TO BE COOLED BY ACCELERATED AIR COOLING AFTER NORMALIZING. MINIMUM TENSILE STRENGTH IS TO BE 95,000 #/□".
5. -6 TO -10 INCL., -20 TO -29 INCL & -32, SAME AS CORRESPONDING DASH NO'S ON 29B101, EXCEPT AS NOTED
6. FINISH - (PBY-5 ONLY) SANDBLAST. METAL SPRAY WITH ALUM. P-AL OUTSIDE, PARAL. INSIDE.
7. MAGNAFLUX EACH WELDED SUBASSEMBLY BEFORE MAJOR ASSEMBLY IS MADE. COMPLETED WELDED ASSEMBLY MAGNAFLUXED BY CIRCULAR METHOD ONLY BOTH BEFORE & AFTER HEAT TREATMENT PROCESS SPEC. = AN-QQ-M-181. LATEST REVISION

DO NOT HEAT TREAT THIS MOUNT FOR B-24A UNTIL PARTS ON 32B408 HAVE BEEN INCORPORATED.

—NOTES—

8. OMIT ALUMINUM SPRAY FROM ALL MACHINED SURFACES.
9. 28B5000 PARTS MADE FOR ASSEMBLY ON 32B408 ARE TO HAVE NO FINISH UNTIL AFTER ASSEMBLY ON 32B408 & THEN FINISHED PER 32B408.
10. USE EITHER GAS WELDING OR ELECTRIC WELDING ON MOUNT.
11. NORMALIZING AFTER ASSEM. BY ELECTRIC WELDING NOT REQ'D. IF ALL COMPONENT PARTS INCLUDING 28B5010 & 28B2002 ARE NORMALIZED PRIOR TO ASSEM.
12. EXTREME CARE SHOULD BE EXERCIZED IN THE WELDING OPERATION ON FORGINGS OF HIGH-CARBON CONTENT IN ORDER TO ELIMINATE CRACKING.

—NOTES—

13. IN HEATING TO STRAIGHTEN THE WELDED ASSY, IT IS PERMISSABLE TO HEAT TO A TEMPERATURE NOT TO EXCEED 1200° F. FOR A PERIOD NOT TO EXCEED ONE MINUTE, WITHOUT NORMALIZING AFTER ASSY.
IF EITHER THE TEMPERATURE OR TIME LIMIT IS EXCEEDED, THE ASS'Y MUST BE NORMALIZED.

15. 28B5276-0, 28B5276-2, 28B5277-0 OR 28B5277-2 MAY BE USED AS ALTERNATES FOR TWO PIECES OF FORGING 28B5010.

PART No	STOCK	MATERIAL	SPEC	REQ
#2 x 3/16 TYPE U-PK DRIVE SCREWS STEEL CAD PLATE				22
28B5010				16
28B2032				4
28B2007-2				4
-45	.050	CM STL SHT		1
-44	.050	CM STL SHT		1
-43	.050			1
-42	.050			1
-41	.050			1
-40	.050			1
28B5000-39	.063 x 4 1/2 x 4 3/4	CM STL SHT	NOTED	1
-36	.063 x 4 x 5	"		1
-35	1 1/4 OD x .049 x 29	CM STL TU		1
-34	" x 26	"		1
-33	1 1/4 OD x .049 x 26	CM STL TU		1
-32	.063 x 2 1/2 x 2 3/4	CM STL SHT		4
-29	x 1 3/8 x 4	"		1
-28	x 1 3/8 x 4	"		1
-27	x 1 3/8 x 4	"		1
-26	x 1 3/8 x 4	"		1
-25	x 1 x 4 1/2	"		1
-24	x 1 x 4 1/2	"		1
-23	x 1 x 4 1/2	"		1
-22	.063 x 1 x 4 1/2	CM STL SHT		1
-21	NOTED			4
-20	1 1/2 OD x .072 x 108	CM STL TU		1
-10	1 3/8 OD x .049 x 28	CM STL TU		1
-9	x 28	"		1
-8	x 29	"		1
-7	x 29	"		1
28B5000-6	1 3/8 OD x .049 x 29	CM STL TU	NOTED	1

PARTS LIST PER ASSY

28B5000

MODEL	NEXT ASSY	REQ
28-5AMN	28P5100	2
PBY-5B	28P5100	2
LB-30	32B408	4
B-24A	32B408	4
28-5MN	28P5100	2
28-5MC	28P5100	2
28-5MA	28P5100	2
28-5ME	28P5100	2
28-5AMC	28P5100	2
PBY-5A	28P5100	2
PBY-5	28P5100	2

REQUIREMENTS PER AIRPLANE

SCALE 1" = 1'-0" NOTED

STAMP PART NUMBER WHERE SHOWN

A.C. NONE	NONE
NAVY NOTED	NOTED
HEAT TREAT	FINISH

NAME: MOUNT ASSEM ENGINE

CONSOLIDATED AIRCRAFT CORP — San Diego, Calif.

OPP HAND

J 28B5000